

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005607**Date Inspected:** 24-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Luan Zhao Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (North of the paint shop)

Segment 3BE

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the side plate to side plate splice welds. The Weld Designations are as follows: SEG016A-009 and SEG016A-010.

This QA Inspector performed a preliminary random visual inspection of the internal structure of this segment. Areas that were marked to be ground and welded were repaired at the time of inspection. No access was available to the external welds at the time of inspection.

Segment 4AE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of side panel to side panel super assembly splice repair welds previously rejected by (UT). The welder is identified as #044837. The weld designation is SEG018A-010. ZPMC QC is identified as Mr. Zhang Zhong. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-Repair.

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## WELDING INSPECTION REPORT

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Shielded Metal Arc Welding (SMAW) in the 2G position of side panel to edge plate super assembly splice repair welds previously rejected by (UT). The welder is identified as #044772. The weld designation is CA008-003. ZPMC QC is identified as Mr. Zhang Zhong. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-Repair.

### Segment 3AE

Shielded Metal Arc Welding (SMAW) in the 3G position of the deck transverse stiffener CJP weld to the edge plate at panel point 21.5. The welder is identified as #048047. The weld designation is SEG018A-010. ZPMC QC is identified as Mr. Geng Wei. The welding variables recorded by QC appear to comply with the applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patterson,Rodney	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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